

Date: Wednesday, 15/08/2007 4:00:34 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 33942	Part Number	: D28571
Estimate Number	: 10345	Drawing Number	: D2857 REV B
P.C. Number	:	Project Number	: N/A
This Issue	: 15/08/2007 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 11 Type : MACHINED PARTS	Due Date	: 15/09/2007
Previous Run	: 31832	Qty:	40
Written By	: <u>John 07-08-16</u>	Um:	Each
Checked & Approved By	:		
Comment	: Est C 00.06.22 Removed P/O for powder coat EC Est D 06.05.01 Added level 8 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.4594 f(s)/Unit Total: 13.7813 f(s)
Material: 2.00" X 1.25"
6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
(M6061T6B200001250)
Batch M 105838

28.02/10/22

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks 5.2"

28.07/12/22

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
Machine per folio D2857-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.10.22 (39)
SA 07.10.22 (39)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2857-1 PAR #: N/A Fault Category: Prod / Machine NCR: Yes No DQA: D Date: 07.11.01
 QA: N/C Closed: 18 Date: 07.11.01

NCR: <u>33942</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-26	3.0	1 part (1st one) the 0.125" 0.150" found in Section A-A was inverted. R.C.: Program error	<u>JP</u> 07.10.26 PC Q51042	Acceptable. Strength not affected as weakest part is at hinge point. Fill out program mod folio sheet.	<u>SD</u> 07.10.26	<u>JP</u> 07.10.26	<u>JP</u> 07.10.26 PC Q51042	<u>JP</u> 07.10.26
07-10-26	3.0	1 part scrap. 96.25° 2 was not fully machined, the tool did not cut enough. - cannot re-machine, or re-position R.C.: Program error.	<u>JP</u> 07.10.26	to update the program to correct errors. Scrap; no replace.	<u>SD</u> 07.10.26	<u>JP</u> 07.10.26	<u>JP</u> 07.10.26 Q51042	<u>JP</u> 07.10.26

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:00:34 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 33942

Part Number: D28571

Job Number:



Seq. #: Machine Or Operation: Description:

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

FL 07.10.27

(39)

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

FL 07.10.29

(39)

7.0 HAND FINISHING 1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

FL 07/10/29

(39)

8.0 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
FL 07/10/29

(X35)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M 105068 - M 105914

BR 07-10-30

(39)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/10/30

(39x)

SD

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/10/30

(39x)

SD

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.31

Job Completion



W 07/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

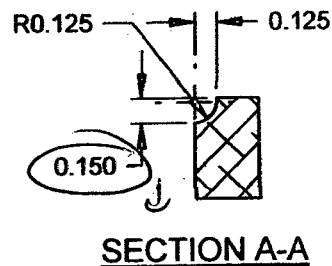
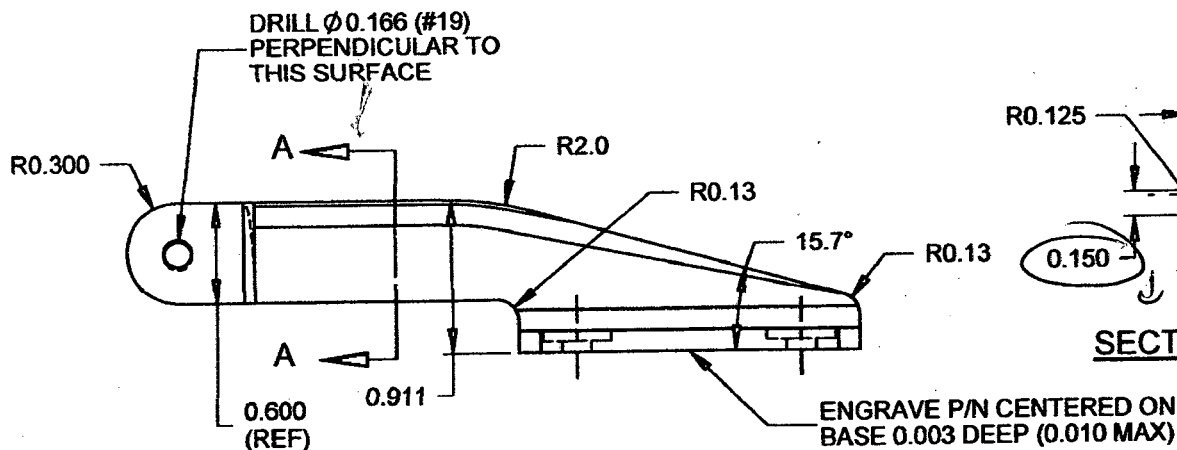
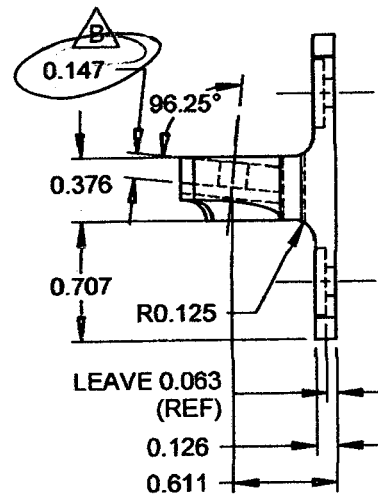
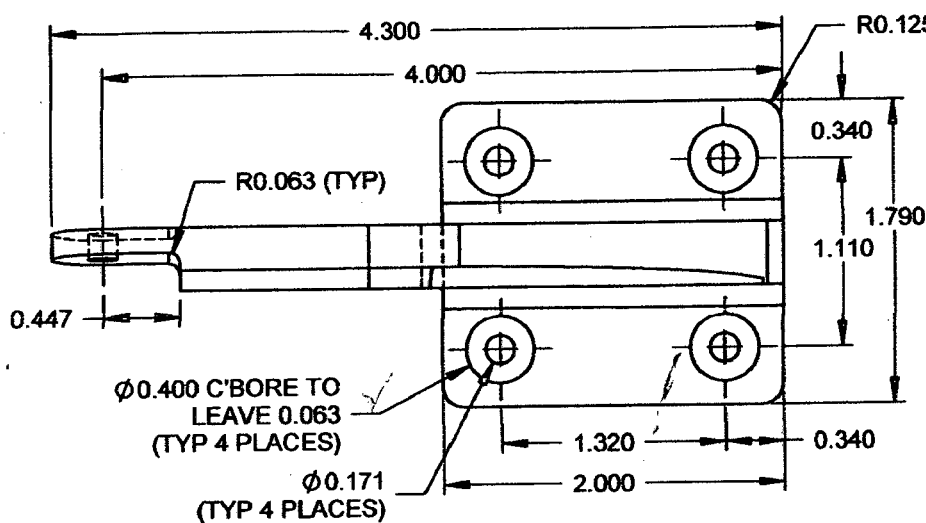
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET		SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

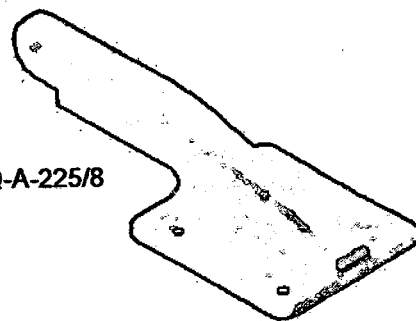
RELEASED
06.10.13



D2857-1 HINGE BRACKET
D2857-2 OPPOSITE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



COPYRIGHT © 1998 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order:	33942
Description: Hinge Bracket		Part Number:	D2857-1
Inspection Dwg: D2857 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.306	/			
4.000	+/-0.010	4.000	/			
0.340	+/-0.010	.340	/			
1.110	+/-0.005	1.110	/			
1.790	+/-0.010	1.791	/			
1.320	+/-0.005	1.320	/			
2.000	+/-0.010	2.000	/			
0.340	+/-0.010	.340	/			
0.447	+/-0.010	.446	/			
Ø0.171	+0.005/-0.000	.174	/			
0.147	+/-0.010	.149	/			
0.376	+/-0.010	.378	/			
0.126	+/-0.010	.127	/			
0.063	+/-0.010	.063	/			
Ø0.166	+0.005/-0.000	Ø.166	/			
0.911	+/-0.010	.910	/			
0.600	+/-0.010	.598	/			
0.125	+/-0.010	.132	/			
0.150	+/-0.010	.144	/			

Measured by:	SN	Audited by:	S.F	Prototype Approval:	N/A
Date:	07.10.25	Date:	07/10/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	